



Dart Aerospace Ltd.
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D3304-041
Job Sheet 198837



Part No: D3304-041

Job Qty: 4 pcs

Part Name: Tube Assembly



Part Weight: 0 lbs

Status: New

Priority: High

Job Created: 8/6/19

Job Tracking No:

Due Date: 8/8/19

Created By: Jason Leroux

Type: SOLD

Description:

Note: URF 19-568 DWG D3304 REV.C IPP: C 04.11.17 Step 13 revised KJ/JLM IPP REV:D 19.07.23 AS PER DWG
REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs	8/8/19	8/8/19	0.00	1.16	Bandsaw - 1		
110	Conventional Lathe - 1 - B4B	4 pcs	8/8/19	8/8/19	0.00	2.22	Conventional Lathe - 1 - B4B		
							Conventional Lathe - 2 - B4B		
120	QC 2	4 pcs	8/8/19	8/8/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Container No: S203076



Part: D3304-041

Job No: 198837

Serial No/Batch: S203076

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 08/07/19

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[Dart Hawkesbury] Job Sheet - Leroux, Jason

					QC 2 - 63	# 19/8/7
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
QC 8 - 35						
QC 8 - 39						
QC 8 - 4						
QC 8 - 44						
QC 8 - 45						
QC 8 - 49						
QC 8 - 58						
QC 8 - 8						
QC 8 - 9						
QC 8 - 68						
QC 8 - 67						
QC 8 - 1 (A)						
QC 8 - 47						
QC 8 - 40						
QC 8 - 52						
QC 8 - 23						
QC 8 - 57						
140 Small Fab - 2 - B4B	4 pcs	8/8/19	0.00 0.93	Small Fab - 1 - B4B	AUG 07 2019	
				Small Fab - 2 - B4B		
				Small Fab - 3 - B4B		
				Small Fab - 4 - B4B		
				Small Fab - 5 - B4B		
				Small Fab - 6 - B4B		
				Small Fab - 7 - B4B		
				Small Fab - 8 - B4B		
150 QC 5	4 pcs	8/8/19	0.00 0.00	QC 5 - 10	DAS 81 9-89	
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		

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160 Large Fab - Welded Assy-2-B4B	4 pcs	8/8/19	0.00 1.28	QC 5 - 61	
				QC 5 - 81	
				Large Fab - 1 - B4B	EL
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
170 QC 9	4 pcs	8/8/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	DAS
				QC 9 - 43	43
				QC 9 - 50	9-89
				QC 9 - 9	
180 QC 5	4 pcs	8/8/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	DAS
				QC 5 - 43	43
				QC 5 - 49	9-89
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190 Powdercoat - 3 Grey Sand - B4B	4 pcs	8/8/19	0.00 0.16	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	AL 19-8-9
				Powdercoat - 4 - B4B	
200 QC 3	4 pcs	8/8/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	

					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
210 Small Fab - 3 - B4B	4 pcs	8/8/19	0.00 0.93		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	NOV 20 2019
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
220 QC 5	4 pcs	8/8/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	NOV 7 6 2019 40
					QC 5 - 61	9-89
					QC 5 - 81	
230 Packaging 3-1 - Stock - B4B	4 pcs	8/8/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC 51459
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	

					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	2-80

240 QC 21 - SA

4

8/8/19

0.00 0.00

pcs

Part Op 110 - Cut blank: 15.75" as per Dwg D3304 Turn as per Dwg D3304 Identify as D3304-1
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - QC8- Inspect parts - second check)

140 - Deburr Drill as per Dwg D3304 using drill Jig D3304-T1 Deburr

150 - (QC5- Inspect part completeness to step on W/O)

160 - Weld bracket as per Dwg D3304 and QSI 004

170 - (QC9- Inspect visual per QSI004- Fusion Welds)

180 - QC5- Inspect part completeness to step on W/O)

190 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: 9:00am OVEN TEMPERATURE: 4:15am

FINISH TIME: 3:45?

200 - (QC3- Inspect Part Finish)

210 - Assemble lanyard and pip pin as per Dwg D3304(SEE NOTE 9) MANUFACTURE LANDYARD AS PER D2690-10 DWG

220 - (QC5- Inspect part completeness to step on W/O)

230 - (Identify as per dwg & Stock Location:)

240 - (QC21- Final Inspection - Work Order Release)

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.875W.065	304 Round Tube .875 X .065W	5.3748 ft (1.3437 ea)	100-Bandsaw - 1	M138403
D3304-5	Bracket	4 pcs (1 ea)	160-Large Fab - Welded Assy-2- B4B	F119599
CBL-1240	Cable	4.1668 ft (1.0417 ea)	210-Small Fab - 3 - B4B	S157330
CBL-460	Loop Sleeve	8 Ea (2 ea)	210-Small Fab - 3 - B4B	S187877
NAS1353DS7S13D	Pin, Quick Release	4 Ea (1 ea)	210-Small Fab - 3 - B4B	S221600

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M304TR0.875W.065	5	13	0
160-Large Fab - Welded Assy-2- B4B	D3304-5	4	0	0
210-Small Fab - 3 - B4B	CBL-1240	4	658	0
	CBL-460	8	729	0
	NAS1353DS7S13D	4	1	0

Part Specifications

Specifications could not be found.

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